

# Work Order ID 64272

Wednesday, December 01, 2010 11:45:49 A

Page 1

Item ID: D3826-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Rib / Gusset Assembly

Start Date: 12/1/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 12/8/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-12-1

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3826

Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

I - use DT9434 to assemble D2325 support gusset together □ 2 - locate D2325 on rib and weld as per dwg D3826 □ A/R ER316 S.S. Rod  
Batch: 1114649

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

10/12/08 @

PLC 10-12-10

6 10/12-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 64272**

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Page 2

Item ID: D3826-041

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Start Date: 12/1/2010 Start Qty: 6.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg &amp; Stock Location:

0.00



Packaging

Basket cell

Memo

0.00

Packaging

10/12/10 (6x)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/14  
CL 10/12/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, December 01, 2010 11:46:00 AM

Page 1

Work Order ID: 64272

Parent Item: D3826-041

Parent Item Name: Rib / Gusset Assembly

Start Date: 12/1/2010


Required Date: 12/8/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2235-1		Manufactured	No				Each	10.0000	1	6			
													
Basket Rib													

Location Loc Qty Loc Code

WA 10  
64109 10

D3929-041		Manufactured	No				Each	5.0000	1	6			
													
Gusset Assembly													

Location Loc Qty Loc Code

WA 5  
63052 5

D3929-042		Manufactured	No				Each	0.0000	1	6			
													
Gusset Assembly													

SY 10/12/08

6x

B64110 14 10/12/08

6x

B64111 6x 10/12/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

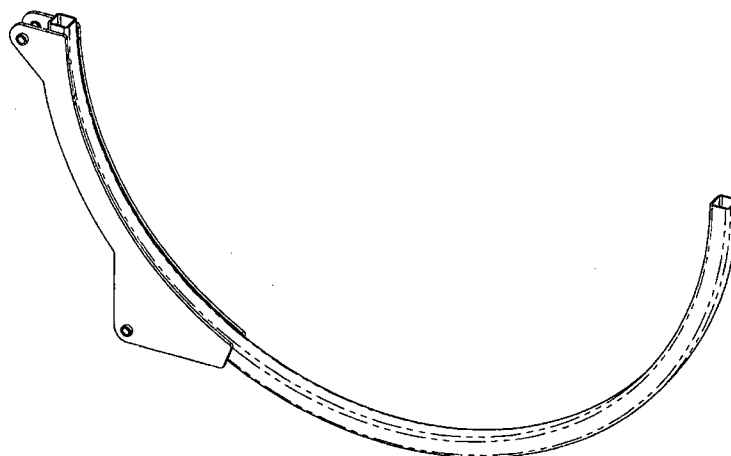
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY



**D3826-041 RIB/GUSSET ASSY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 64272  
BS 10-12-1

**RELEASED**  
8/10/12 MB

- NOTES:  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 3.32 lbs

B	D3929-041/-042 WERE D2325 (ZN D3-1 & ZN D6-2). UPDATED WEIGHT (ZN A8-1). REASON: SEE NCR#09-042.	MB	09.04.16
A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>MB</u>		
DRAWN	<u>MB</u>		
CHECKED	<u>MB</u>		
MFG. APPR.	<u>MB</u>		
APPROVED	<u>MB</u>		
DE APPR.	<u>MB</u>		
DATE	09.04.16		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA  
DRAWING NO. **D3826** REV. B  
SHEET 1 OF 2  
TITLE **RIB/GUSSET ASSY** SCALE NTS

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W/O:		WORK ORDER CHANGES					
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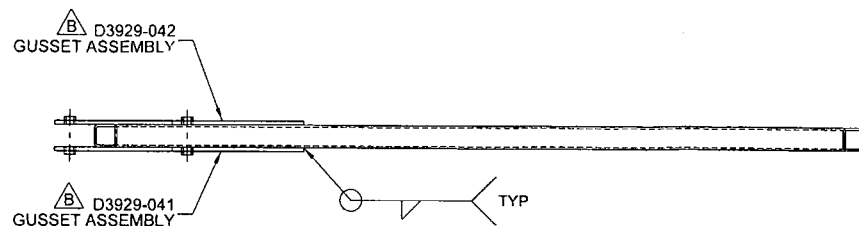
**NOTE:** Date & initial all entries



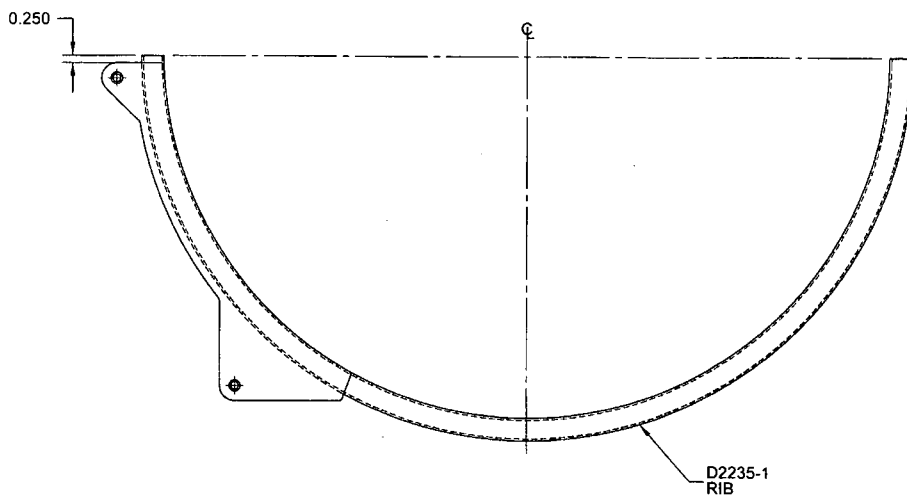
8 7 6 5 4 3 2 1

D  
C  
B  
A

D  
C  
B  
A



*w/o 64272*



**D3826-041 RIB/GUSSET ASSY**

**RELEASED**  
*8/10/4/2-141*

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D3826</b>	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>RIB/GUSSET ASSY</b>	NTS
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8 7 6 5 4 3 2 1

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